

*SPLIT L*

Date: Tuesday, 11/14/2006 10:08:31 AM  
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 29411 <i>7</i>		
Estimate Number	: 12576		
P.O. Number	: <i>N/A</i>	Part Number	: D3562041
This Issue	: 11/14/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3562 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 29411	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/24/2006
Checked & Approved By	: <i>[Signature]</i> 06-11-14	Qty:	5 Um: Each
Comment	: Est Rev: A New Issue 06-11-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>328215</i>

Check Material for any Dents or Defects

*PE 06-11-22 5*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion ~~to 02-16" long~~ as per Dwg D3562

2-Deburr and bevel ends for welding

*PE 06-11-22 5*  
*PE 06-11-23 5*

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

*PE 06-12-27 (5)*

4.0	D2734	206 Step Endplate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:	
Qty Part Number	Description Batch
2 D2734	End Cap <i>329340</i>

*PE 06-12-27 5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 11/14/2006 10:08:31 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 29411

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35601

ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3560-1

Arm

329447

*P.E. 06.12.27 5*

6.0

D35603

ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM

Batch:

329449

*P.E. 06.12.27 5*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

Use DT8893 To Weld Arms

A/R Aluminum Rod M100237 & M19612

*P.E. 06.12.28 5*

2-Grind end cap welds flush as per Dwg D3562

*P.E. 06.12.28 5*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/01/03 (5)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/01/03 (5)*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1.

*FCP 07/01/04 (5)*

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and bevel aft end for welding.

2-Weld as per Dwg D3562

a/r AL ROD

Batch: M100237 M19612

*P.E. 07.01.08 5*  
*P.E. 07.01.08 5*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-01-10	116	grind end cap flush .	lt.	07-01-09	5			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 11/14/2006 10:08:31 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 29411

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/10 (5)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/10 (5)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Y/L

07/01/11 x5

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y/L

07/01/11 x5

PTB

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: 102098

SP/Y/L

07/01/11 (5)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

07-03-26

(1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

07/04/05

Job Completion



W 07/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070204	15	scratches on step		repaint 1	<i>[Signature]</i> 070204	<i>[Signature]</i>		

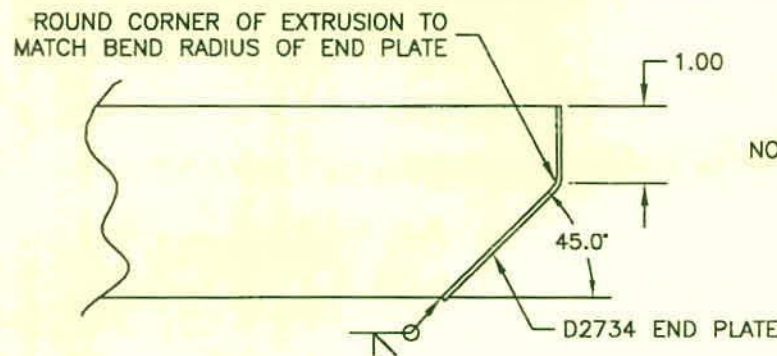
NOTE: Date & initial all entries



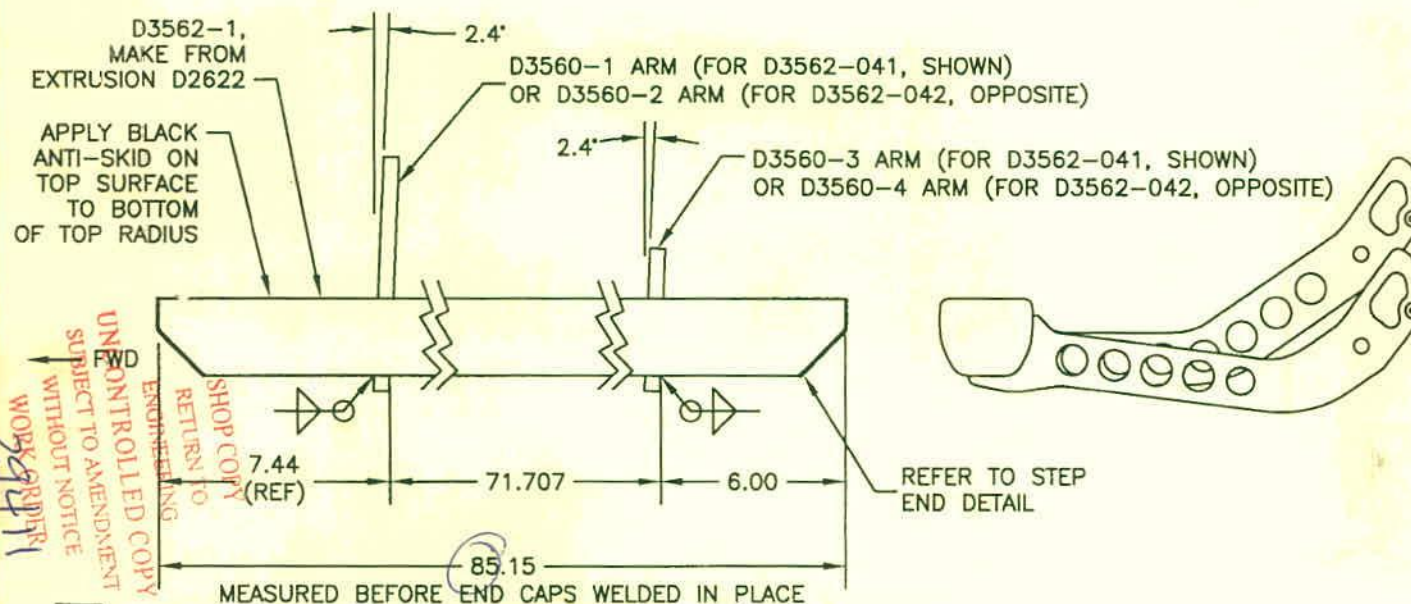


DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
06.09.26	06.09.26	D3562
DATE	TITLE	STEP WELDMENT
A	NEW ISSUE	SCALE
		REV. A
		SHEET 1 OF 1
		NFS

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL  
NOT TO SCALE



**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

2.11.07

UNCONTROLLED COPY  
SUSJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
29471

